

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019948**Date Inspected:** 06-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Mr. An Qing Xing.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

**SEGMENT # 10W:**

Shielded Metal Arc Welding (SMAW) welding of welds joint SEG061A-011/SEG063A-002 (10BW+10CW, BP-SP Hold Back), and Welder is identified as 067752. ZPMC Quality Control (QC) is identified as Mr. Wang zhu . The welding variables appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

SMAW welding of welds joint OBW10B-002 (10AW+10BW, SP-SP CW Side), and Welding Repair Report (WR) B-WR14920, Welder is identified as 067656. ZPMC Quality Control (QC) is identified as Mr. Wang zhu . The welding variables appeared to comply with the Applicable WPS-345-SMAW-4G (4F)-FCM-REPAIR.

Flux Cored Arc (FCAW) welding of weld joint BP103-001-022(10BW+10CW), and Welder is identified as 053316. ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. The welding variables appeared to comply with the Applicable WPS-B-T-2233-B-U2-F.

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FCAW welding of weld joint SEG063B-011(10BW+10CW), and Welder is identified as 040609. ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. The welding variables appeared to comply with the Applicable WPS-B-T-2233-TC-U4b-F.

### SEGMENT 10E

Shielded Metal Arc Welding (SMAW) welding of welds joint OBE10-004,003 (10AE+10BE), and Welding Repair Report (WR) B-WR14932, Welder is identified as 040320. ZPMC Quality Control (QC) is identified as Mr. Liu Huajie. The welding variables appeared to comply with the Applicable WPS-345-SMAW-4G (4F)-FCM-REPAIR-1.

SMAW welding of welds joint DP714-001-037 (10AE+10BE), and Welder is identified as 044515. ZPMC Quality Control (QC) is identified as Mr. Liu Huajie. The welding variables appeared to comply with the Applicable WPS-B-T-3213-B-U3b.

Flux Cored Arc (FCAW) welding of weld joint SP377-001-035,036/SP378-001-011,012(10AE+10BE), and Welder is identified as 040367. ZPMC Quality Control (QC) is identified as Mr. Liu Huajie. The welding variables appeared to comply with the Applicable WPS-B-T-2132.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Michael Ng (15921845703), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Tharikoppada,Reddy	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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